

Work Order ID 148082

Friday, June 24, 2016 9:08:36 AM

148082

Page 1

Item ID: D119-796-021 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection
Start Date: 8/22/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 9/20/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: DEM Date: 16/06/24 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D119-796-021	A								
IIN-D119-796	E								
100	Pick Kit	0.00							
100									
Packaging	Memo	0.00							
Packaging	Photocopy bluefile and create labels as per PPP D119-796-021 chg 003/ D119-646-041 paperwork								
110		0.00							
110									
HandFinish	Memo	1.16							
Hand Finishing	ASSEMBLE AS PER DWG AND NOTES 8,9,10,11								
	ASSEMBLE WITH PROSEAL BATCH: <u>135370</u>								
	2-INSTALL DECAL D2729-4								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Work Order ID 148082

Friday, June 24, 2016 9:08:36 AM

148082

Page 2

Item ID: D119-796-021

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 8/22/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/20/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.08							DAS 9 9-89
Quality Control									
130	Identify as per dwg & Stock Location: <u>Ship</u>	0.00							
130									
Packaging	Memo	0.04							
Packaging	Identify and pack for shipping as per PPP D119-796-021 Location: _____ PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.02							DAS 21 9-89
Quality Control									SEP 20 2016

SEP 20 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
240 0 24-0				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

Friday, June 24, 2016 9:08:36 AM

Page 1
10

Work Order ID: 148082

148082

Parent Item: D119-796-021

D119-796-021

Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 8/22/2016

Required Date: 9/20/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 15-05-012 JLM VERIFIED BY:DD IPP
REV:B 15.08.25 AS PER IIN REV.E DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D119-646-041

Manufactured

No

110

Each

2.0000

2

2

D119-646-041

**

Replacement Skidtube with Wearpads, Fits LH or RH

Location

Loc Qty

Loc Code

FG

2

144509

1

146618

1

D119-796-151

Manufactured

No

110

Each

1.0000

1

1

D119-796-151

**

FWD Crosstube Installation with Step (no hardware)

Location

Loc Qty

Loc Code

FG

1

146654

1

D119-796-251

Manufactured

No

110

Each

1.0000

1

1

D119-796-251

**

AFT Crosstube Installation with Step (no hardware)

Location

Loc Qty

Loc Code

FG

1

146639

1

DAS 36 9-89
16/09/19
B148119 (1x)
B148115 (1x)
DAS 36 9-89
16/09/19
149602 (1x)
DAS 36 9-89
16/09/19
149584 (1x)

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

Friday, June 24, 2016 9:08:36 AM

Page 2

Work Order ID: 148082

148082

Parent Item: D119-796-021

D119-796-021

Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 8/22/2016

Required Date: 9/20/2016

Start Qty: 1.00

Required Qty: 1.00

D2652

Manufactured No

110

Each

461.0000

48

48

D2652

Bushing

148315

DAS
6
9-89

Location

Loc Qty

Loc Code

FG

45

31985

45

ST009

110

145958

110

ST012a

306

147559

306

D3407-041

Manufactured No

110

Each

11.0000

2

2

D3407-041

Tow Ring

145818

DAS
6
9-89

Location

Loc Qty

Loc Code

st529

11

145441

11

D3417-5

Manufactured No

110

Each

85.0000

4

4

D3417-5

Washer

147540

DAS
6
9-89

Location

Loc Qty

Loc Code

ST035

85

145908

85

SEP 08 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

Friday, June 24, 2016 9:08:36 AM

Page 3

Work Order ID: 148082

148082

Parent Item: D119-796-021

D119-796-021

Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 8/22/2016

Required Date: 9/20/2016

Start Qty: 1.00

Required Qty: 1.00

D3456-1

Manufactured No

110

Each

141.0000

2

2

D3456-1

Washer

149710

DAS
6
9-89

Location

Loc Qty

Loc Code

FG

7

25701

7

ST037

59

141989

9

144158

50

ST038A

75

147066

25

147799

50

D3672-3

Manufactured No

110

Each

1,173.000

48

48

D3672-3

Washer, Phenolic

148409

DAS
6
9-89

Location

Loc Qty

Loc Code

FG

100

133083

52

134449

48

FP001

213

132639

213

ST049

360

139583

40

142571

320

ST051A

500

146277

500

SEP 08 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

Friday, June 24, 2016 9:08:36 AM

Page 4

Work Order ID: 148082

148082

Parent Item: D119-796-021

D119-796-021

Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 8/22/2016

Required Date: 9/20/2016

Start Qty: 1.00

Required Qty: 1.00

D3672-7

Manufactured No

110

Each

1,178.000

48

48

D3672-7

Washer, Phenolic

Location

Loc Qty

Loc Code

FG

40

129987

25

133986

15

ST049

138

134786

138

ST051A

1000

142572

500

147220

500

45

DAS
6
9-89

D3883-1

Manufactured No

110

Each

19.0000

2

2

D3883-1

Saddle, Outboard LH

147687

DAS
6
9-89

Location

Loc Qty

Loc Code

ST404

19

142477

9

142773

10

D3883-2

Manufactured No

110

Each

18.0000

2

2

D3883-2

Saddle, Outboard RH

148743

DAS
6
9-89

Location

Loc Qty

Loc Code

ST404

18

142486

11

144927

7

SEP 08 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

Friday, June 24, 2016 9:08:36 AM

Page 5

Work Order ID: 148082

148082

Parent Item: D119-796-021

D119-796-021

Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 8/22/2016

Required Date: 9/20/2016

Start Qty: 1.00

Required Qty: 1.00

D3884-1 Manufactured No

110 Each 19.0000 2 2

D3884-1

Saddle, Inboard LH

148628

DAS
6
9-89

Location

Loc Qty

Loc Code

ST404

19

142461

9

142674

10

D3884-2 Manufactured No

110 Each 18.0000 2 2

D3884-2

Saddle, Inboard RH

148706

DAS
6
9-89

Location

Loc Qty

Loc Code

ST404

18

142471

11

144929

7

D3886-041 Manufactured No

110 Each 5.0000 4 4

D3886-041

Lug Assembly

147690

DAS
6
9-89

Location

Loc Qty

Loc Code

ST528

5

142775

5

SEP 08 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

Picklist Print

Friday, June 24, 2016 9:08:36 AM

Page 6

Work Order ID: 148082

148082

Parent Item: D119-796-021

D119-796-021

Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 8/22/2016

Required Date: 9/20/2016

Start Qty: 1.00

Required Qty: 1.00

AN3C46A

Purchased

No

110

Each

322.0000

8

8

AN3C46A

Bolt

DAS
6
9-89

Location

Loc Qty

Loc Code

FG

10

122843

10

OVER002

210

134795

70

M134591

70

M134794

70

ST346

102

M132522

33

M133917

69

AN3C50A

Purchased

No

110

Each

135.0000

16

16

AN3C50A

Bolt

135309

SEP 08 2016
DAS
6
9-89

Location

Loc Qty

Loc Code

OVER002

130

M135054

130

ST346

5

M133842

2

M134494

3

Friday, June 24, 2016 9:08:36 AM

Shop Packet Print

Page 6

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

Friday, June 24, 2016 9:08:36 AM

Page 7

Work Order ID: 148082

148082

Parent Item: D119-796-021

D119-796-021

Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 8/22/2016

Required Date: 9/20/2016

Start Qty: 1.00

Required Qty: 1.00

AN4C6A

Purchased

No

110

Each

459.0000

24

24

AN4C6A

Bolt

135442

DAS
6
9-89

Location

Loc Qty

Loc Code

FG

14

103344

4

121657

10

OVER002

300

m134861

150

m134955

150

ST345

145

m134502

145

MS21043-3

Purchased

No

110

Each

1,352.000

24

24

MS21043-3

Nut

135442 X17

DAS
6
9-89

Location

Loc Qty

Loc Code

FG

80

103691

80

FP001

11

m130673

11

GA

315

m133990

315

OVER007

400

m134861

400

ST302

440

m134502

40

m135058

400

ST304

106

m131340

106

7

SEP 08 2016

Friday, June 24, 2016 9:08:36 AM

Shop Packet Print

Page 7

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

Friday, June 24, 2016 9:08:36 AM

Page 8

Work Order ID: 148082

148082

Parent Item: D119-796-021

D119-796-021

Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 8/22/2016

Required Date: 9/20/2016

Start Qty: 1.00

Required Qty: 1.00

MS21043-4

Purchased

No

110

Each

1,233.000

26

26

MS21043-4

135390

Nut

Location

Loc Qty

Loc Code

FG	40	
104603	40	
GA	17	
m132803	17	
OVER007	600	
m134754	300	
m134943	300	
ST302	576	
m131697	104	
m133769	12	
m134502	300	
m134634	160	

DAS
6
9-89

MS21043-5

Purchased

No

110

Each

138.0000

8

8

MS21043-5

135470

Nut

Location

Loc Qty

Loc Code

FG	20	
101418	20	
GA	76	
116548	76	
ST302	42	
m132382	9	
m134502	33	

SEP 08 2016

DAS
6
9-89

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
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				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

Friday, June 24, 2016 9:08:36 AM

Page 9

Work Order ID: 148082

148082

Parent Item: D119-796-021

D119-796-021

Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 8/22/2016

Required Date: 9/20/2016

Start Qty: 1.00

Required Qty: 1.00

MS21250-05048

Purchased

No

110

Each

106.0000

8

8

MS21250-05048

Bolt (use MS21250-05-048)

DAS
6
9-89

Location

Loc Qty

Loc Code

over006

100

m134973

100

ST295

6

m133694

6

8

NAS1149C0332R

Purchased

No

110

Each

5,810.000

24

24

NAS1149C0332R

WASHER

DAS
6
9-89

Location

Loc Qty

Loc Code

FP001

1808

m132930

1004

m134073

128

m134962

676

GA

141

m133284

141

ST266

3861

m134736

1861

m135046

2000

24

NAS1149C0432R

Purchased

No

110

Each

1,557.000

48

48

NAS1149C0432R

WASHER

13 5297 x9
13 544 x39

DAS
6
9-89

Location

Loc Qty

Loc Code

GA

1272

m125807

427

m134676

845

ST266

285

m131452

285

SEP 08 2016

Friday, June 24, 2016 9:08:36 AM

Shop Packet Print

Page 9

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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OTHER : _____																																																																									

Picklist Print

Page 10

Friday, June 24, 2016 9:08:36 AM

Work Order ID: 148082

148082

Parent Item: D119-796-021

D119-796-021

Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 8/22/2016

Required Date: 9/20/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0532R

Purchased

No

110

Each

483.0000

16

16

NAS1149C0532R

WASHER

135038

DAS
6
9-89

Location

Loc Qty

Loc Code

GA

60

116513

60

ST266

423

m133031

23

m134756

200

m135056

200

SEP 08 2016

139x89x35crate

Purchased

No

110

Each

8.0000

1

1

139x89x35crate

Agusta Crate

MS21920-28

Purchased

No

Each

153.0000

2

MS21920-28

Clamp

16/09/15
DAS
36
9-89

Location

Loc Qty

Loc Code

FG

1

105884

1

LG050

142

M135007

67

M135008

25

M135009

50

LG051

1

M132169

1

LG057

2

M134130

2

ST5543

7

M134590

7

SEP 08 2016

DAS
6
9-89

Friday, June 24, 2016 9:08:36 AM

Shop Packet Print

Page 10

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

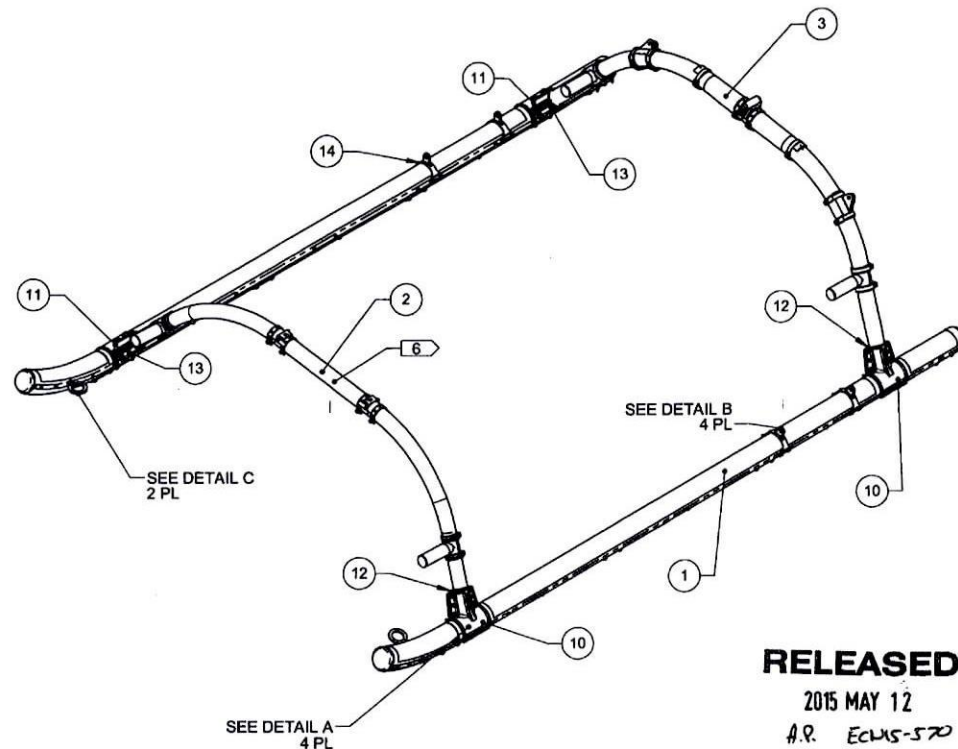


QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
BAC BC BAC				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

ITEM	QTY -021	P/N	DESCRIPTION
	X	D119-796-021	STD GEAR WITH STD WEARPADS
1	2	D119-646-041	STD SKIDTUBE WITH STD WEARPADS
2	1	D119-796-151	XTUBE ASSY (AW119 MKII FWD)
3	1	D119-796-251	XTUBE ASSY (AW119 MKII AFT)
4	48	D2652	BUSHING
5	2	D3407-041	TOW RING
6	4	D3417-5	WASHER
7	2	D3456-1	WASHER
8	48	D3672-3	PHENOLIC WASHER
9	48	D3672-7	PHENOLIC WASHER
10	2	D3883-1	SADDLE, OUTBOARD LH
11	2	D3883-2	SADDLE, OUTBOARD RH
12	2	D3884-1	SADDLE, INBOARD LH
13	2	D3884-2	SADDLE, INBOARD RH
14	4	D3886-041	LUG ASSEMBLY
15	8	AN3C46A	BOLT
16	16	AN3C50A	BOLT
17	24	AN4C6A	BOLT
18	24	MS21043-3	NUT, SELF-LOCKING
19	26	MS21043-4	NUT, SELF-LOCKING
20	8	MS21043-5	NUT, SELF-LOCKING
21	8	MS21250-05048	BOLT
22	24	NAS1149C0332R	WASHER
23	48	NAS1149C0432R	WASHER
24	16	NAS1149C0532R	WASHER



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2015 MAY 12

A.P. ECLIS-570

D119-796-021 STD GEAR WITH STD WEARPADS

NOTES:
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: N/A
 4) UNITS: N/A
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: INSTALL D2729-4 RED DECAL IN LOCATION SHOWN
 7) WEIGHT: 122.7 LBS

A	NEW ISSUE	AP	15.04.01
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	AJS	DRAWING NO.	REV. A
MFG. APPR.	DD	D119-796-021	SHEET 1 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	STD GEAR WITH STD WEARPADS	NTS
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w/o 148082

2m 16/06/24

MS21250-05048 BOLT
NAS1149C0532R WASHER
D3672-7 WASHER
2 PL
10

D3883-1 SADDLE (LHS)
D3883-2 SADDLE (RHS)

AN3C50A BOLT
D3672-7 WASHER
D2652 BUSHING
4 PL
10

D3884-1 SADDLE (LHS)
D3884-2 SADDLE (RHS)

D3672-7 WASHER
NAS1149C0532R WASHER
MS21043-5 NUT
2 PL
10

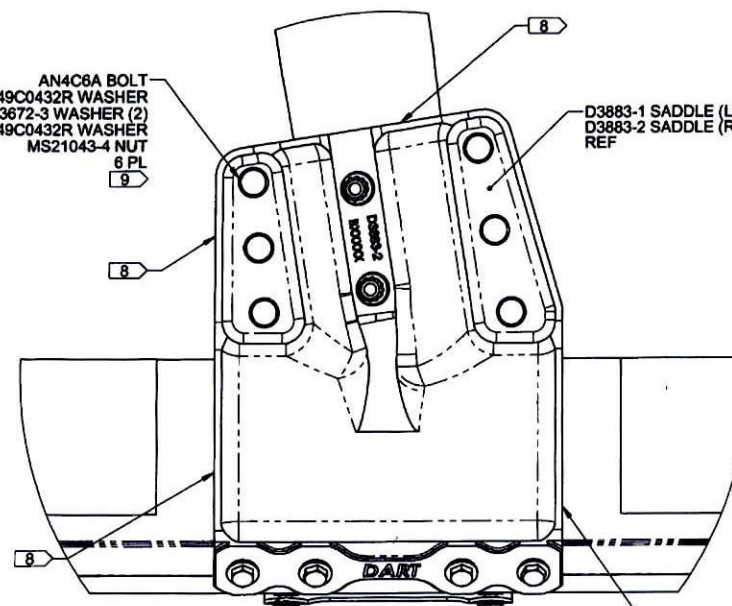
D2652 BUSHING
D3672-7 WASHER
NAS1149C0332R WASHER
MS21043-3 NUT
4 PL
10

DETAIL A
4 PL

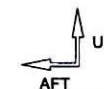


AN4C6A BOLT
NAS1149C0432R WASHER
D3672-3 WASHER (2)
NAS1149C0432R WASHER
MS21043-4 NUT
6 PL
9

D3883-1 SADDLE (LHS)
D3883-2 SADDLE (RHS)
REF



DETAIL A



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2015 MAY 12

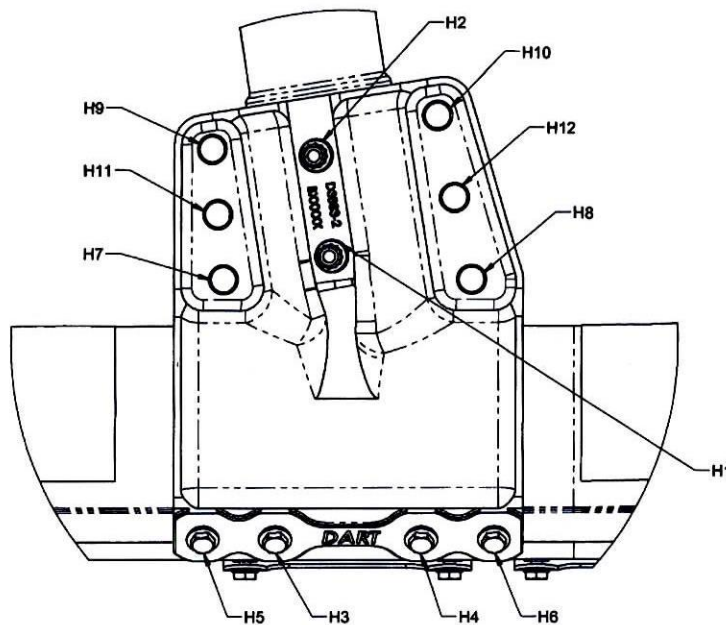
A.P. EN 15-570

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: N/A
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) APPLY A CONTINUOUS BEAD OF SIKAFLEX -241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT IN THE LOCATIONS SHOWN INCLUDING THE FOLLOWING:
 - A) ALONG SADDLE/CROSSTUBE INTERFACE
 - B) BETWEEN THE SADDLE FLANGES
 - C) ALONG SADDLE/SKIDTUBE INTERFACE
- 9) LIGHTLY TIGHTEN ALL BOLTS IN THE NUMERICAL ORDER SPECIFIED ON SHEET 3, THEN TIGHTEN TO SPECIFIED TORQUE IN TABLE 1.
- 10) INSTALL WET WITH SIKAFLEX -241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT
- 11) ALL NUTS TO BE INSTALLED ON THE INBOARD SIDE

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DESIGN	AP	DART AEROSPACE LTD	
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CHECKED	AJS	DRAWING NO.	REV. A
MFG. APPR.	DD	D119-796-021	SHEET 2 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	STD GEAR WITH STD WEARPADS	NTS
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SUPPLEMENTAL VIEW - TORQUE SEQUENCE

TABLE 1: TORQUE SEQUENCE AND MAX TORQUE

TORQUE SEQUENCE	PART NUMBER	TORQUE
H1	MS21250-05048	66-85 IN-LBS (7.3 - 9.6 n-m)
H2	MS21250-05048	66-85 IN-LBS (7.3 - 9.6 n-m)
H3	AN3C50A	15-25 IN-LBS (1.7 - 9.6 N-m)
H4	AN3C50A	15-25 IN-LBS (1.7 - 9.6 N-m)
H5	AN3C50A	15-25 IN-LBS (1.7 - 9.6 N-m)
H6	AN3C50A	15-25 IN-LBS (1.7 - 9.6 N-m)
H7	AN4C6A	50-70 IN-LBS (5.7 - 7.9 N-m)
H8	AN4C6A	50-70 IN-LBS (5.7 - 7.9 N-m)
H9	AN4C6A	50-70 IN-LBS (5.7 - 7.9 N-m)
H10	AN4C6A	50-70 IN-LBS (5.7 - 7.9 N-m)
H11	AN4C6A	50-70 IN-LBS (5.7 - 7.9 N-m)
H12	AN4C6A	50-70 IN-LBS (5.7 - 7.9 N-m)

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A.P. EN 15-570

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	MFG. APPR.	DD	D119-796-021	SHEET 3 OF 4
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	STD GEAR WITH STD WEARPADS	NTS
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D3407-041 TOW RING
D3417-5 WASHER

9

INBOARD

D3417-5 WASHER
D3456-1 WASHER
MS21043-4 NUT

8 9 11

DETAIL C
2 PL

D2852 BUSHING
NAS1149C0332R WASHER
MS21043-3 NUT
2 PL

8 9 10

INBOARD

D3886-041 LUG ASSEMBLY

9

D2852 BUSHING
AN3C46A BOLT
2 PL

8 9 10

DETAIL B
4 PL

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2015 MAY 12

A.P. EN15-570

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: N/A
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) INSTALL WET WITH SIKAFLEX -241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT
- 9) APPLY FAY SEAL AND FILLET SEAL USING SIKAFLEX -241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT
- 10) TORQUE AN3 HARDWARE TO 20-25 IN-LBS
- 11) TORQUE AN4 HARDWARE TO 50-70 IN-LBS

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DESIGN	AP	DART AEROSPACE LTD	
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CHECKED	AJS	DRAWING NO.	REV. A
MFG. APPR.	DD	D119-796-021	SHEET 4 OF 4
APPROVED	HS	TITLE	SCALE
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